



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D4593-3**Job Sheet 192219****Part No:** D4593-3**Job Qty:** 5 pcs**Part Name:** Cover**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 3/19/19**Job Tracking No:****Due Date:** 4/19/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV A IPP REV:A NEW ISSUE 12-02-27 JLM VERIFIED BY:DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Bandsaw - 1	5 pcs		4/19/19	0.00	0.00	Bandsaw - 1		522	19/03/26
110	HAAS 4 Axis - B4B	5 pcs		4/19/19	0.00	4.38	HAAS - 1 - B4B		522	19/03/26
							HAAS - 2 - B4B		9-89	
							HAAS - 3 - B4B			
							HAAS - 4 - B4B			
120	QC 2	5 pcs		4/19/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 56			
							QC 2 - 57			

**Container No:** S166430**Part:** D4593-3**Job No:** 192219**Serial No/Batch:** S166430**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 03/26/19

130 QC 8	5 pcs	4/19/19	0.00 0.00	QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 8 - 12	
				QC 8 - 14	m 19/03/26
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
140 Handfinish - 1-1 Chemical-B4B	5 pcs	4/19/19	0.00 0.21	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/03/27
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	

				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 6 Fire Red - B4B	5 pcs	4/19/19	0.00 0.17	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	3/19-03-28
				Powdercoat - 4 - B4B	
160 QC 3	5 pcs	4/19/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	MAR 29 2019
				QC 3 - 19	DAS 40 9-89
170 Packaging 3-1 - Stock - B4B	5 pcs	4/19/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS 28 9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	

				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	5 pcs	4/19/19	0.00 0.00	QC 21 - SA - 21	APR 02 2019 21 9:28
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op **100** - (Bandsaw) Cut blank: 1.500" x 2.500" x 4.120" long
 Descriptions: **110** - (HAAS CNC vertical machine #1) Machine D4493-3 as per Folio FB093 and Dwg Dwg Rev: A FOLIO
 REV: A
120 - QC2- Inspect parts off machine FAI/FAIB
130 - QC8- Inspect parts - second check
140 - Chemical Conversion Coat per QSI005 4.1
150 - Fire Red(Ref:4.3.5.10) per QSI005 4.3 Heat oven at temperature for 45 minutes before putting part in oven
 by: Start Time: 1:40 Oven Temperature: 320° Finish Time: 2:10 M/29/2019
160 - QC3- Inspect Part Finish
170 - Identify as per dwg & Stock Location:
180 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	1.7500 ft (.35 ea)	100-Bandsaw - 1	<u>5149553</u> <u>5124463</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.500X2.500	2	12	0

Part Specifications
Specifications could not be found.

Plex 3/20/19 11:20 AM dart.leroux.jason

DART AEROSPACE LTD		Work Order:	
Description: Cover		Part Number:	D4593-3
Inspection Dwg: D4593 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.635	+/-0.010	0.638	✓		Ø0.220	+0.005/-0.001
Ø1.250	+/-0.010	1.250	✓		Ver	
1.175	+/-0.010	1.175	✓		Ver	
2.350	+/-0.010	2.350	✓		Ver	
1.750	+/-0.010	1.750	✓		Ver	
2.750	+/-0.010	2.750	✓		Ver	
Ø0.750	+0.010/-0.000	Ø0.752	✓		Ver	
1.500	+/-0.010	1.500	✓		H.G.	
0.450	+/-0.010	0.450	✓		Ver	
Ø0.185	+0.005/-0.001	Ø0.185	✓		G.P.	
0.456 deep	+/-0.010	0.456	✓		G.P.	
0.491	+/-0.010	0.491	✓		H.G.	
0.450	+/-0.010	0.450	✓		H.G.	
1.450	+/-0.010	1.450	✓		Ver	
15°	+/-0.5°	15°	✓		D.A.G.	
4.000	+/-0.010	4.000	✓		Ver	
3.344	+/-0.010	3.344	✓		Ver	
2.161	+/-0.010	2.161	✓		Ver	
1.081	+/-0.010	1.081	✓		Ver	
0.592	+/-0.010	0.592	✓		Ver	
0.550	+/-0.010	0.550	✓		Ver	
0.72	+/-0.030	0.720	✓		D.G.	
1.200	+/-0.010	1.200	✓		H.G.	
1.35	+/-0.030	1.35	✓		Ver	
Ø1.000	+/-0.010	Ø1.000	✓		Ver	
0.85	+/-0.030	0.845	✓		H.G.	
0.20 x 0.25°	+/-0.030 x +/-0.5°	0.20x25°	✓		Ver	

Measured by: DAS 52		Audited by: [Signature]		Preliminary Approval:	
Date: 9-89 19/03/26		Date: 19/03/26		Date:	
Rev	Date	Change	Revised by		Approved
A	12.03.08	New Issue	KJ		[Signature]